



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6505G00831-3G

Job Sheet 168795



000314

Part No: RBW6505G00831-3G

Job Qty: 1 ea

Part Name: Tail Rotor Gear Box Support Trolley Adapter



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/23/17

Job Tracking No:

Due Date: 12/8/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Eagle Copters Maintenance Ltd (CEAGL03)

823 McTavish Road NE Calgary, AB, T2E 7G9 Canada ph:(403) 250-7370

Note: DWG rbw6505g00831-3g Rev2 IPP Rev A 17.11.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/7/17	12/7/17	0.00	0.00	Start Up Container		MLC
110	Small Fab	1 pcs	12/8/17	12/8/17	0.00	1.00	Small Fab		MLC
120	QC	1 pcs	12/8/17	12/8/17	0.00	0.00	QC5		MLC
130	Packaging	1 pcs	12/8/17	12/8/17	0.00	0.00	Packaging3		MLC
140	QC21-FG	1 Ea	12/8/17	12/8/17	0.00	0.00	QC21		MLC

Part Op 90 - DWG needs engineering sign off for Ferrule 3896T31 and cable CL-2-C
Descriptions: 110 - Assemble as per DWG. Sheet 1 & 2

DAS
21

JAN 3 1 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	crimp 3896T31 3016493	12	32	0	0
	split ring 90177A219 3015388	6	0	0	0
	90949A016 3015389	2	0	0	0
	91251A421 3037411	2	0	0	0
	91251A426 3015390	2	0	0	0
	screw 91259A583 3015387	2	0	0	0
	91654A076 3015391	4	0	0	0
	92620A540 3016392	4	0	0	0
	94744A240 3015393	4	0	0	0
	95395A226 3015394	2	0	0	0
	98099A031 3015395	2	0	0	0
	CL-2-C	2	41	0	0
	RB41009 3021040	1	0	0	0
	RBW6505G00831-3G-1	1	0	0	0
	RBW6505G00831-3G-19	1	0	0	0
	RBW6505G00831-3G-21	1	0	0	0
	RBW6505G00831-3G-23	1	0	0	0
	RBW6505G00831-3G-25	1	0	0	0
	RBW6505G00831-3G-41	3	0	0	0
	RBW6505G00831-3G-7	1	0	0	0

Part Specifications

Specifications could not be found.



S037489



Tail Rotor Gear Box Support Trolley Adapter

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

PART NO: RBW6505G00831 - 3G
Original Serial #: S037489

Revision:

Operation:

Change No:

Start up Operation

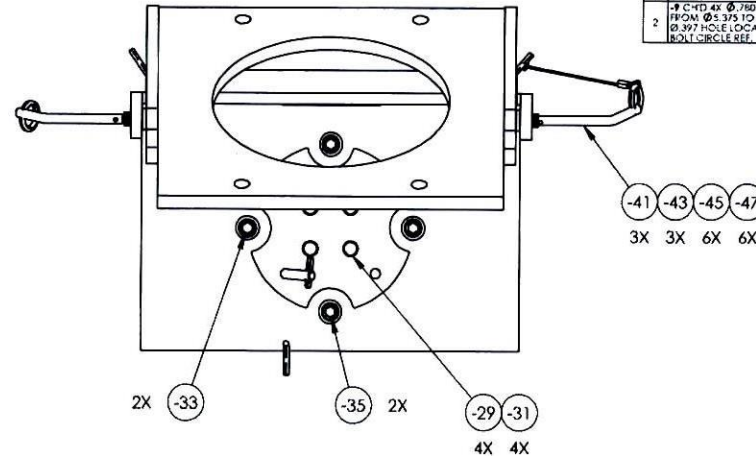
01/31/18

Job No: 168795

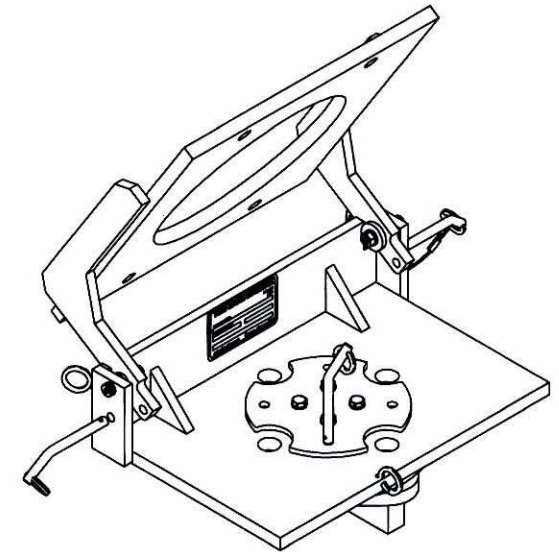
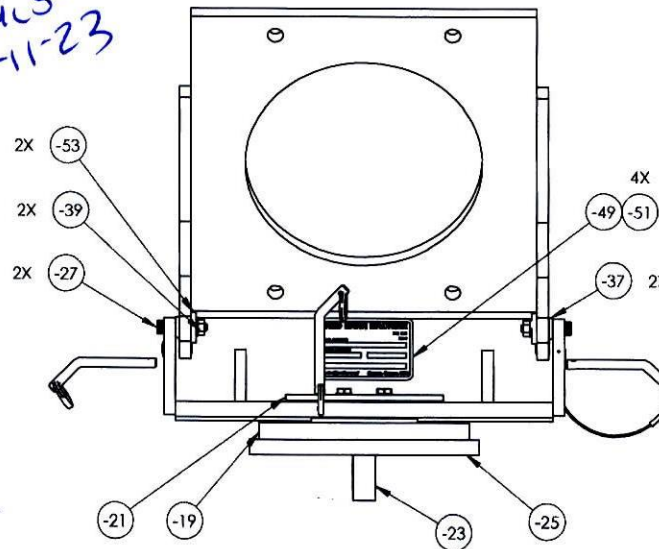
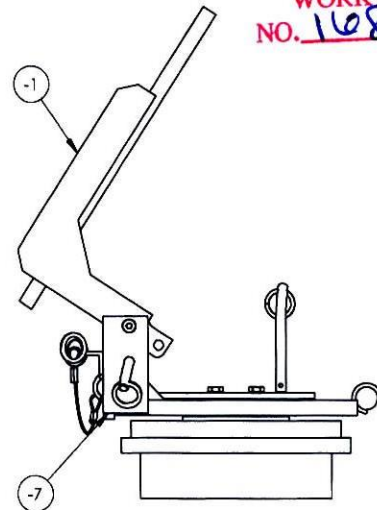
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED SHEET 1a FOR -41. SHEET 5 CHD -5 DIMENSION LOCATION WAS 4.235 & 7.255	5/10/2013	CFS	
2	-9 CHD 42 Ø .780 HOLE R.C. FROM Ø 5.375 TO Ø 5.512 -19 CHD COUNTER BORED HOLES R.C. FROM Ø 5.375 TO Ø 5.512 -23 CHD HOLE LOCATIONS FROM 5.38 TO 5.51 -25 CHD 3/8-24 AND Ø .397 HOLE LOCATIONS FROM 2X 1.90 AND 2X 3.80 TO 2X 1.95 AND 2X 3.90 AND ADDED D5.512 R.O.L.T. CIRCLE REF	7/12/2013	FJC	HW

TEO ATTACHED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 11687015 M.C.S
17-11-23



RB RED BARN MACHINE	
TITLE TROLLEY ADAPTER, TGB SUPPORT	
DWG NO. RBW6505G00831-3G	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1 OR .0150	DRAWN BY: CLOUGH APPROVED: <i>D. Weir</i> TEST FINISH SPEC 1. BREAK ALL SHARP EDGES .015 x 45° 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE 1:4	DATE 2/8/2012
SHEET 1 OF 16	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

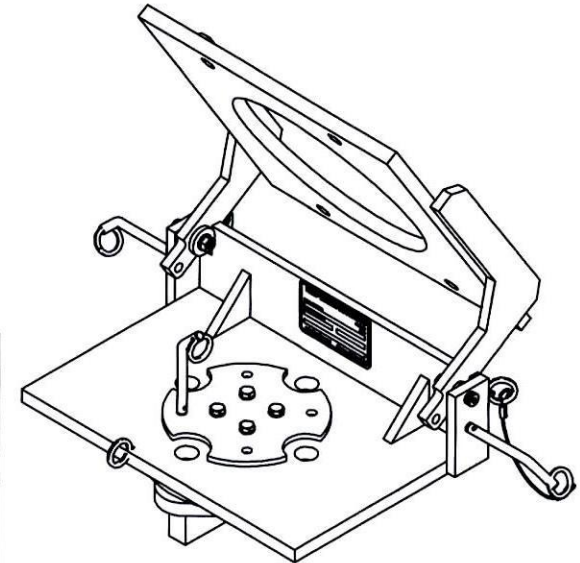
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL

TEO ATTACHED



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	LEG ASSY. WELDMENT			3
	1		-3		PLATE	A36 P&O	1/2 X 11-5/8 X 11-5/8	4
	2		-5		LEG	A36 P&O	1/2 X 6 X 7-3/8	5
X			-7	1	SWIVEL PLATE WELDMENT			6
1			-9		PLATE	A36 P&O	1/2 X 8-1/8 X 12-11/16	7
1			-11		BACK PLATE	A36 P&O	3/8 X 3-1/8 X 12-5/8	8
2			-13		END	A36 P&O	3/8 X 1-1/2 X 3-5/16	9
2			-15		GUSSET	A36 P&O	3/8 X 1-3/16 X 1-3/16	10
1			-17		SHELF	1018	1/8 X 3/4 LEG X 12-7/16	11
			-19	1	SWIVEL BASE	1018	Ø7 X 1-3/8	12
			-21	1	SWIVEL PLATE	A36 P&O	3/16 X 5-1/2 X 5-1/2	13
			-23	1	BAR	6061	3/4 X 1-1/2 X 6-5/8	14
			-25	1	MOUNT PLATE	6061	1/2 X 6-1/8 6-1/8	15
		B/O	-27	2	SHOULDER SCEW	STEEL	Ø5/16 X 1 SHOULDER, 1/4-20 MCMASTER-CARR #91259A583	1
		B/O	-29	4	HEX HEAD CAP SCREW	STEEL	1/4-20 UNC X 3/4 MCMASTER-CARR #92620A540	1
		B/O	-31	4	FLAT WASHER	STEEL	Ø9/32 I.D. X 1/2 O.D. MCMASTER-CARR #94744A240	1
		B/O	-33	2	SOCKET HEAD CAP SCREW	STEEL	3/8-24 UNF X 5/8 MCMASTER-CARR #91251A421	1
		B/O	-35	2	SOCKET HEAD CAP SCREW	STEEL	3/8-24 UNF X 1-1/4 MCMASTER-CARR #91251A426	1
		B/O	-37	2	WASHER	BRASS	Ø11/32 I.D. X 11/16 O.D. X .11 - .14 MCMASTER-CARR #25395A226	1
		B/O	-39	2	LOCKNUT	STEEL	1/4-20 UNC MCMASTER-CARR #90949A016	1
			-41	3	PIN	STEEL	Ø5/16 X 2-1/2 USABLE MCMASTER-CARR #90146A059 (MODIFIED)	16
		B/O	-43	3	LANYARD	COATED GALV. STEEL	{7X7 CABLE} Ø1/16 X 6 CARR LANE #CL-2	1
		B/O	-45	6	OVAL SLEEVE	ALUMINUM	Ø1/16 X 3/8 MCMASTER-CARR #3896T31	1
		B/O	-47	6	SPLIT RING	STEEL	Ø1.10 O.D. MCMASTER-CARR #90177A219	1
		B/O	-49	1	RED BARN PLACARD	ALUMINUM	RB41009	1
		B/O	-51	4	#2 DRIVE SCREW	STEEL		N/S
		B/O	-53	2	WASHER	STEEL	Ø13/32 I.D. X 1 O.D. X .17-.2 MCMASTER-CARR #98099A031	1

 RED BARN MACHINE	
TITLE TROLLEY ADAPTER, TGB SUPPORT	
DWG NO. RBW6505G00831-3G	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: CLOUGH APPROVED <i>D. Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AW139
SCALE 1:6	DATE 2/6/2012
SHEET 2 OF 16	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					